

Work Order ID 54212

December 03, 2009 9:21:26 AM



Page 1

Item ID: D205-596-105

Accept



Setup Start



Revision ID: B

Stop



Item Name: Crosstube Fwd Extended

Start Date: 12/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

RL

Date: 09/12/3

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D205-596	Rev B

100 0.00



DOCUMENT CONTROL

DC

Memo 0.00

Document Control

Photocopy D205-594 bluefile & type labels per PPP D205-596-105 CHG002

for MF 10/01/02

110



BENDING MACHINE - CROSSTUBES

CNC Bend 2

CNC Alpha 160 Bender

Memo 0.00

1X A 09-12-15

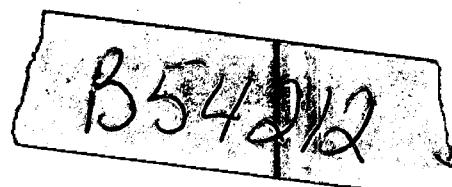
120



Crosstubes

Crosstubes

Memo 0.00
Mark 23.92" for cutting from tangential line in the straight section from D2889
as per Dwg wall template



N/A
12 09-12-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54212

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Page 2

Item ID: D205-596-105

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Setup Start



Revision ID: B

Item Name: Crosstube Fwd Extended

Stop



Start Date: 12/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC15- Crosstube Dimensional Check

→ cut bottom of line →
Memo

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

⇒ Sol 12/15



140



Crosstubes

Crosstubes

0.00

Memo

0.00

Crosstubes

1-Cut as per Dwg D205-596-105[1]

2-Deburr & Inspect for surface damage. Polish cut surface. Scribe part # and batch # on one end of tube.

→ AW 10-01-04

150



QC

Quality Control

QC15- Crosstube Dimensional Check

0.00

Memo

0.00

⇒ Sol 12/15



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NOTE: Date & initial all entries

Work Order ID 54212

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Item ID: D205-596-105

Accept



Setup Start



Revision ID: B

Stop



Item Name: Crosstube Fwd Extended

Stop



Start Date: 12/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

QC:

Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start



Stop

Sequence ID/
Work Center ID

190



Crosstubes

Operation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Crosstubes

Memo

0.00

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area

with 41058 wash 'n' wipe

2- Apply magnobond 6398 as per dwg D205-596-105 Magnobond 6398

Batch: 112417

EXP: 01/2011

3- Inst

Torque: m 10/01/12

m 10/01/12

200



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

→ 10/01/12

71

0.00

210



Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D205-596-105

Location: _____

PPP Rev: E

10/13 sf

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 54212

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Item ID: D205-596-105

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Start Date: 12/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 12/22/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

220



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

10/01/14 HJ

Memo

0.00

MF 10-1-14

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

December 03, 2009 9:21:26 AM

Page 1

Work Order ID: 54212



Parent Item: D205-596-105RevB



Parent Item Name: Crosstube Fwd Extended

Start Date: 12/3/2009

Required Date: 12/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D6005-180RevA

Manufactured

No

110

Each

11.0000

1.0000

Crosstube Material

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

LG

11

39734

11

D2893-1RevB

Manufactured

No

190

Each

72.0000

2.0000

2.75 Support

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
------------------	----------------	-----------------

Location

Main Warehouse

ST

72

25657

6

47109

2

47637

16

51775

19

53125

19

53340

10

TX MB 09-12-15 ✓

M 10/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Page 2

December 03, 2009 9:21:26 AM

Work Order ID: 54212



Parent Item: D205-596-105RevB



Parent Item Name: Crosstube Fwd Extended

Start Date: 12/3/2009

Required Date: 12/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21920-25		Purchased		No		190	Each	201.0000	4.0000			

Clamp(per MIL-DTL-8783C)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	201	
107456	2	
108111	3	
108975	17	
109181	42	
109644	10	
111282	4	
111429	1	
<u>112495</u>	22	
112919	25	
113281	25	
113282	50	

W 10/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 54212



Parent Item: D205-596-105RevB



Parent Item Name: Crosstube Fwd Extended

Start Date: 12/3/2009

Required Date: 12/22/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3595-063-450RevA		Manufactured	No			190	Each	196.9689	4.0000			

RUBBER CUSHION

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse LG	92	
	52447	
Main Warehouse ST	104.9689	
	38959	2
	43210	2.59
	46465	0.3789
	53775	100

ML 10/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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PARTS LIST:

Qty	Part Number	Description
X	D205-596-105	CROSSTUBE ASSEMBLY, HI-HI FWD
1	D6005-180	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURE FROM D6005-180
FINISHED LENGTH = 134.40 ± 0.02
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH
VIBRATING STYLUS
- 7) WEIGHT: 40 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO
BENDING IS 6% BASED ON O.D.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2893-1 THAT
WILL BE IN CONTACT WITH THE CROSSTUBE. LET CURE FOR 12 HOURS AFTER INSTALLATION
AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-25 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE D2893-1
SUPPORT ON THE TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE
CROSSTUBE SUPPORT.
- NOTE: IT IS ACCEPTABLE TO SUBSTITUTE MS21920-25 CLAMPS WITH LONGER (MS21920-26) OR
SHORTER (MS21920-24) CLAMPS TO ACCOMODATE VARYING DIAMETERS. ENSURE THERE IS A
MINIMUM OF 1.5 THREADS IN SAFETY ON THE NUTS.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54212
PL 0912-3

DEO ATTACHED**RELEASED**
06.01.14/M

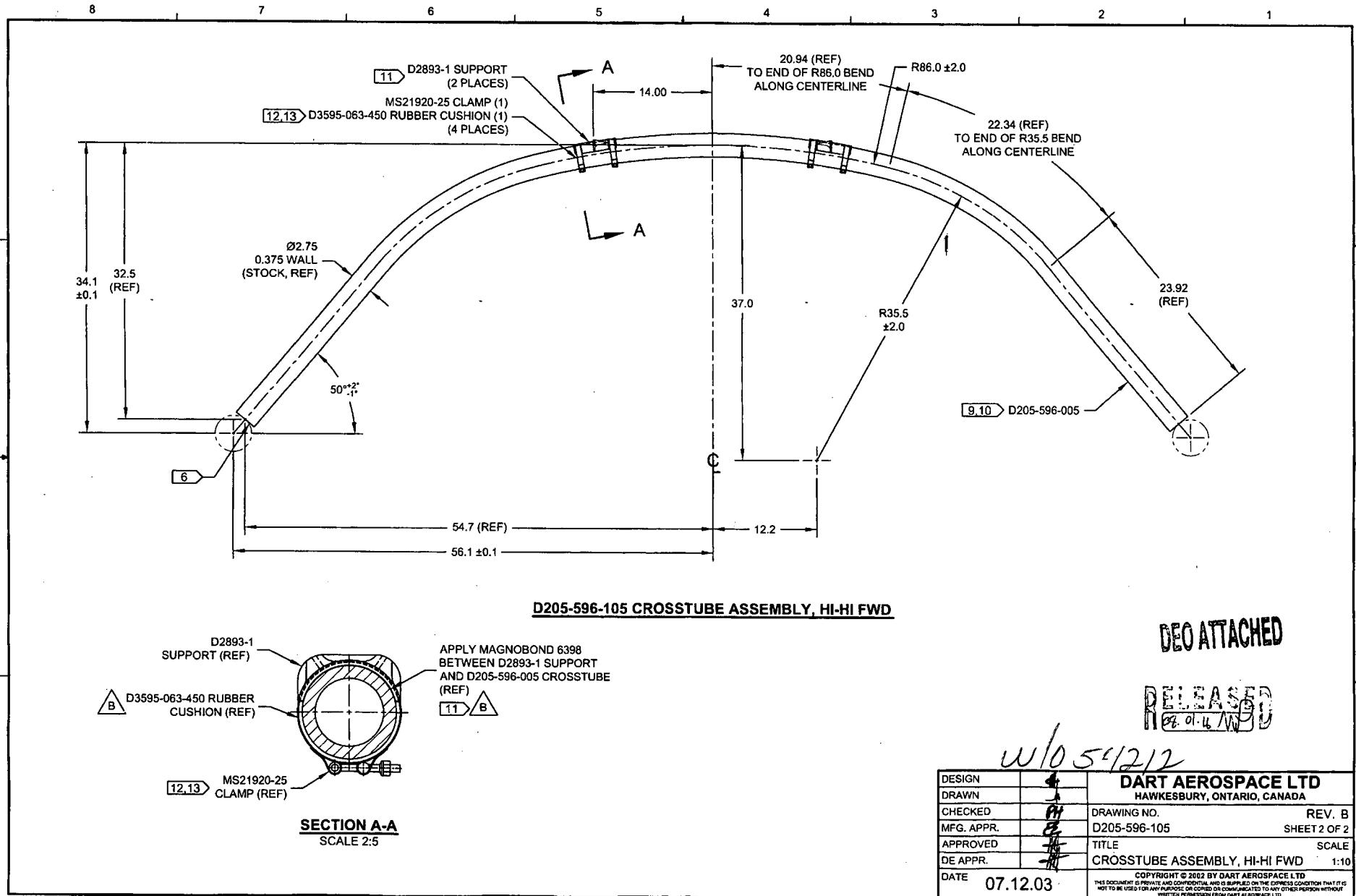
B	SUPPORT NOW MAGNOBONDED; REMOVE D2856-600-851 ABRASION STRIP; UPDATED NOTES; ADDED D3595-063-450 CUSHION; MS21920-25 WAS MS21920-24		MB	07.12.03
A	NEW ISSUE		DS	02.11.20
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN				
CHECKED	DRAWING NO. D205-596-105		REV. B	
MFG. APPR.				SHEET 1 OF 2
APPROVED	TITLE CROSSTUBE ASSEMBLY, HI-HI FWD		SCALE	
DE APPR.				NTS
DATE	07.12.03		COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DRAWING NO. D205-596-105	TITLE CROSSTUBE	REV. B	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D205-596-105-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>LP</i>	CHECKED <i>PS</i>	MFG. APPR. <i>M</i>	APPROVED <i>MD</i>	DE APPR. <i>MD</i>		
DATE 09.05.01	DATE 09.05.15	DATE 09/06/22	DATE 09/06/22	DATE 09.06.22	DATE 09.06.22	

W/0 54212

CHANGE:
ADD THE FOLLOWING CROSSTUBE ASSEMBLY:

Part Number	Description
D205-596-105B	CROSSTUBE ASSEMBLY (214 HI-HI FWD)

THE D205-596-105B CROSSTUBE HAS THE SAME PARTS LIST AS THE D205-596-105 CROSSTUBE. HOWEVER, INSTALL THE SUPPORTS AS SHOWN IN FIGURE 1 OF THIS ENGINEERING ORDER. THE NEW KIT IS OTHERWISE ASSEMBLED PER THE D205-596-105 CROSSTUBE.

RELEASED
09/06/22 AP

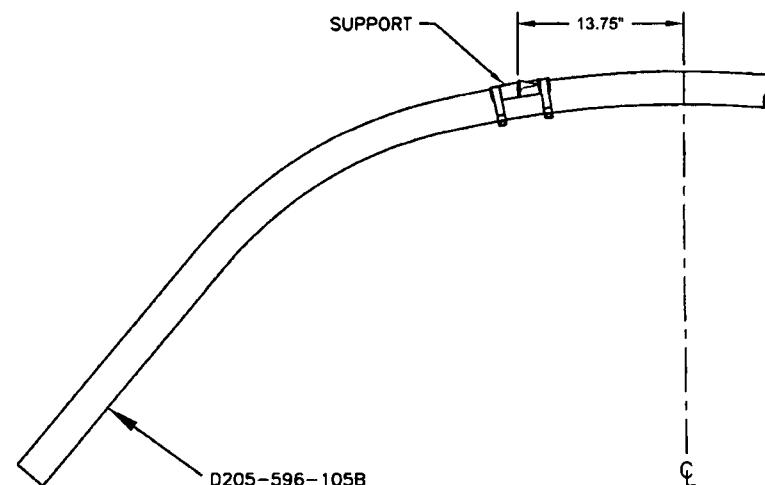


FIGURE 1 - SUPPORT INSTALLATION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

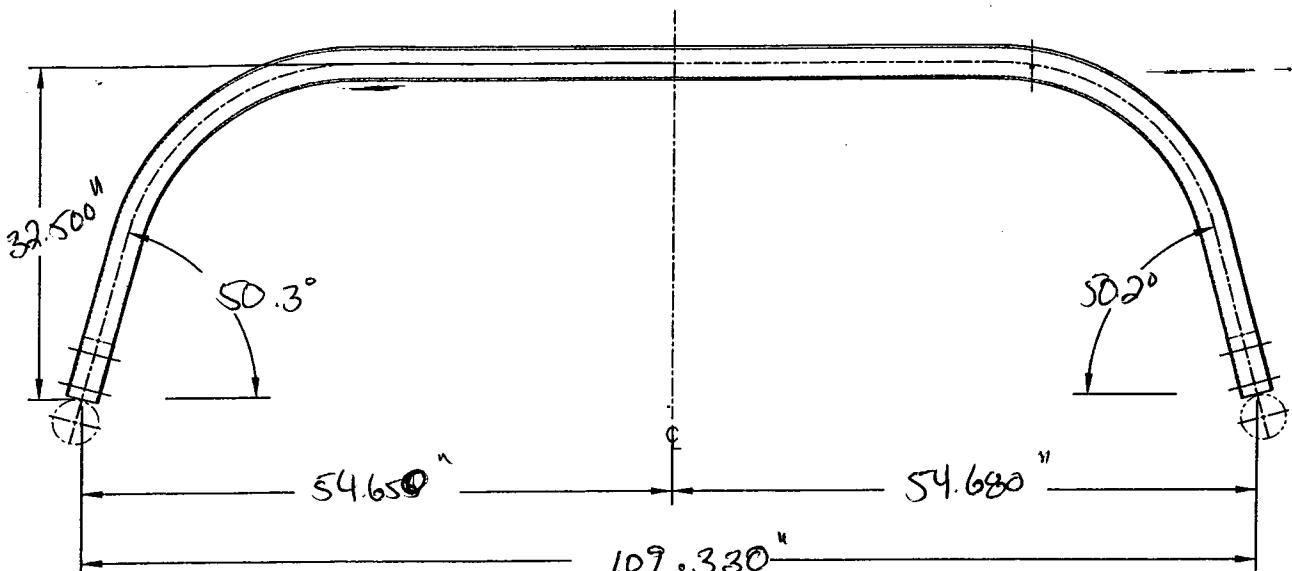
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DART AEROSPACE LTD	Work Order:	541212
Description: Crosstube High-High Fwd	Part Number:	D205-596-105
Inspection Dwg: D205-596-105	Rev: B	Page 1 of 1

Required Dimension	Min	Max
Height	32.4	32.6
1/2 Span	54.6	54.8
Angle	49	52
Total Span	109.2	109.6



Comments

QC15 Inspection	8
Date	09/12/15

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	08.04.21	Dwg Rev updated	KJ/JM	JM

W/O:		WORK ORDER CHANGES					
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